

Clean Version of all pending Claims 1-22:

C1
1. Recyclable heat-sealable multi-layer polyester material suitable for the production of beverage-tight containers in which the polyester resin forming the layers of the multilayer material is an aromatic polyester resin, comprising a layer of a foamed sheet having density lower than 700 kg/m^3 and, adhered to the foamed sheet, a heat-sealable film of polyester resin, having a melting point from 50° to 200° C , said material having creased on it a pattern suitable to develop by folding the shape of a container, the creased pattern being foldable along the creased lines without breakage.

3. Multi-layer material according to claim 2 in which the polyester film is obtained from a resin with melting point from 80 to 110° C .

4. Material according to claim 1 in which the polyester film is a coextruded dual layer film, one layer of which is formed of a low melting polyester having a melting point from 50° to 200° C and the other layer is a polyester having a melting point higher than 200° C .

C2
5. Multi-layer material according to claim 1 in which the polyester film is a film subjected on one side to a treatment capable to impart gas barrier properties or is coated with a layer of material having gas barrier properties, the polyester film having oxygen permeation rate lower than $70 \text{ ml/m}^2 / 24 \text{ h/atm}$ (ASTM 1434).

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C3
7. Material according to claim 6 in which the polyester film is metallized with Al or coated with a layer of [aluminum] alumina or silicon oxide.

8. Multi-layer material according to claim 6 in which the polyester film is coated with a layer of potassium or lithium polysilicates.

9. Material according to claim 1 in which the polyester film is obtained from a copolyethylene terephthalate in which more than 10% of the units deriving from terephthalic acid are substituted with units deriving from isophthalic acid.

10. Multi-layer material according to claim 1 in which the polyester film is made to adhere to the foamed sheet by using a polyester glue or by hot lamination.

11. Multi-layer material according to claim 1 in which the foamed sheet has a density from 10 to 500 kg/m^3 .

12. Multi-layer material according to claim 1 in which the foamed sheet has a density 12. from 100 to 200 kg/m³.

13. Multi-layer material according to claim 1 having a thickness from 0.2 to 3 mm.

14. Multi-layer material according to claim 13 having a thickness from 0.2 to 1.5 mm.

15. Multi-layered material according to claim 1 in which the polyester resin of the foam sheet is selected from polyethylene terephthalate and copolyethylene terephthalates in which up to 20 % of the units derives from isophthalic acid.

~~16. Beverage-tight-recyclable containers for beverages or foods manufactured from the multi-layer material according to claim 1.~~

~~17. Containers according to claim 16 in which the layer that comes into contact with the beverage or food is made of a polyester film adhered to the foamed polyester sheet, and in which the closure is realized by heat sealing on itself the polyester film adhered to the foamed sheet.~~

18. Containers according to claim 17 for fruit juices or sterilized milk in which the polyester film is treated on the side adhered to the foamed sheet with a material capable of conferring barrier properties corresponding to oxygen permeation rate lower than 70 ml/m²/24h/atm.

19. Containers according to preceding claim 18 in which the oxygen permeation rate of the treated polyester film is less than 10 ml/m²/24h/atm.

20. Containers according to preceding claim 19 in which the oxygen permeation rate is less than 0.3 ml/m²/24h/atm.

21. Containers according to claim 19 in which the polyester film is coated with a layer aluminum or Al and/or Si oxide.

22. Multilayer material according to claim 1 in which the polyester forming the layer forming the multilayer material is an aromatic polyester obtained by polycondensation of a copolyethylene terephthalate in which 1 to 20% in moles of the units deriving from terephthalic acid are substituted by units derived from isophthalic acid and/or naphthalene dicarboxylic acids.